



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3274-041BENT
Job Sheet 205237



Part No: D3274-041BENT

Job Qty: 5 pcs

Part Name: Skidtube Assembly 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/6/20

Job Tracking No:

Due Date: 1/27/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV G SHEET 2 IPP REV:A 14.01.17 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	5 pcs	1/27/20	1/27/20	0.12	1.11	Skidtubes - Bend		MGB
120	QC 5	5 pcs	1/27/20	1/27/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	5 pcs	1/27/20	1/27/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S245973



Part: D3274-041BENT

Job No: 205237

Serial No/Batch: S245973

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/09/20

140 QC 21 - SA	5 pcs	1/27/20	0.00 0.00	Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
					JAN 09 2020

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Bend FWD end of tube using bend
Descriptions: prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274. 2- Test fit FWD cap.
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: LG002) LOCAITON : LG002
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2600-1-190	Extrusion Round 3" 206	5 pcs (1 ea)	110-Skidtubes - Bend - 1	5113022 (x7) 5235271 (x3)

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2600-1-190	5	59	0

Part Specifications				
Specifications could not be found.				

Plex 1/6/20 11:27 AM Dart.lajeunesse.marie

G

Qty	Qty	Part Number	Description
-041	-041	D3274-041	SKIDTUBE ASSEMBLY
X	X	D3274-043	SKIDTUBE ASSEMBLY
	X	D3274-046	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D3274-048	EXTRUSION
1	1	D3274-049	AFT CAP
12	12	D3274-050	CROSS RAIL SPACER
12	12	D3274-051	CROSS RAIL SPACER
1	1	D3274-052	FLAT WEB
1	1	D3274-053	FLAT WEB
1	1	D3274-054	FLAT WEB
1	1	D3274-055	FLAT WEB
1	1	D3274-056	FLAT WEB
1	1	D3274-057	FLAT WEB
1	1	D3274-058	FLAT WEB
1	1	D3274-059	FLAT WEB
1	1	D3274-060	FLAT WEB
1	1	D3274-061	FLAT WEB
1	1	D3274-062	FLAT WEB
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1	1	D3274-069	FLAT WEB
1	1	D3274-070	FLAT WEB
1	1	D3274-071	FLAT WEB
1	1	D3274-072	FLAT WEB
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1	1	D3274-199	FLAT WEB
1	1	D3274-200	FLAT WEB

GENERAL NOTES:

1. MATERIAL: WA
2. FINISH: ON 3211485
3. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
4. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
5. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
6. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
7. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
8. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
9. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
10. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
11. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
12. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
13. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4
14. CHEMICAL CONVERSION COAT PER DART Q81 006 4.1 PRIOR TO INSTALLING D3274-041 WEB FRAME (PER 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 006 4.2.1.3.3. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 006 4.4

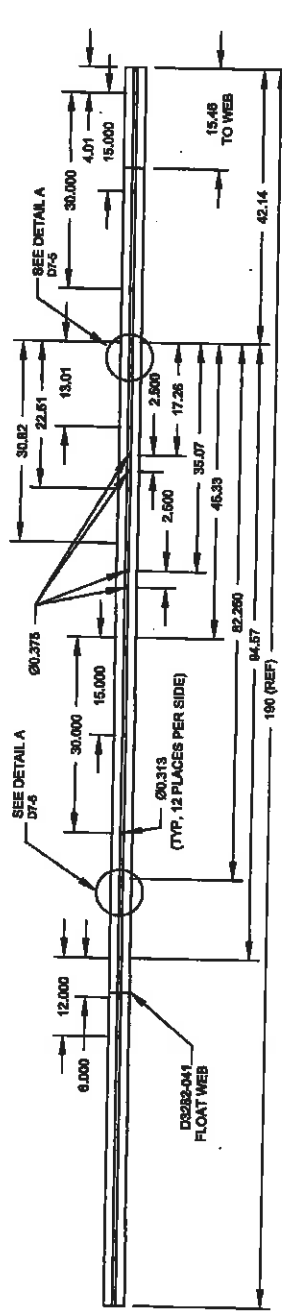
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G

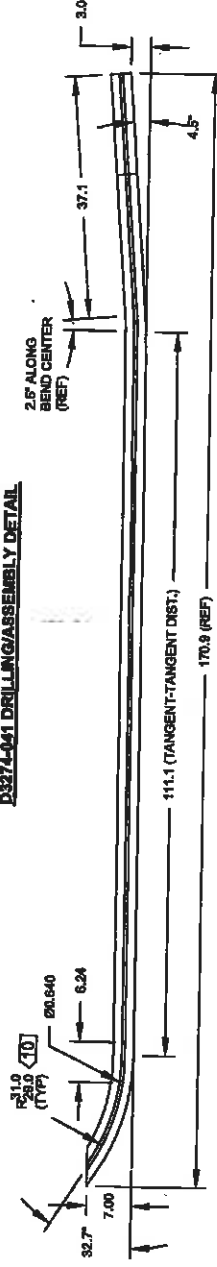
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R 2016-07-26
ECU/11-016

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 205277-105-06
2001-06

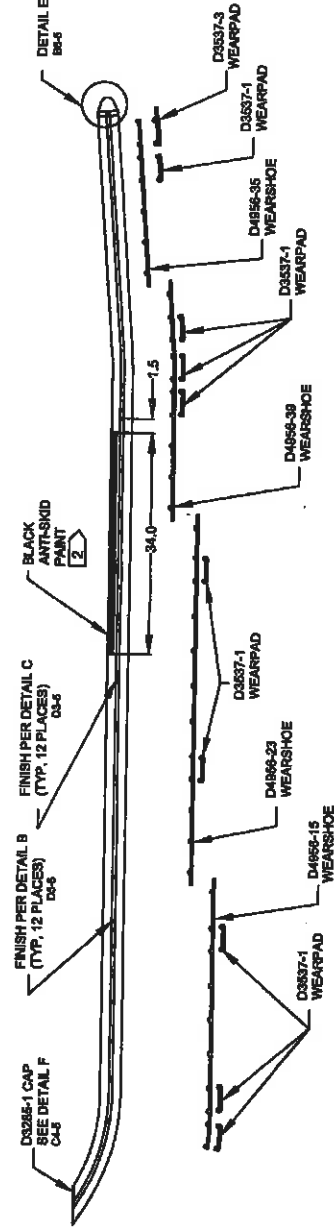
REV.	DESCRIPTION	BY	DATE
G	ADD -046 CONFIGURATION (FOR PH) ZN AG-4, AG-6	DS	18.04.25
F	REVERSE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-0208-042 REV Q	DS	14.04.15
E	REVERSE NOTE 2: FINISH NOW PRIMER/PAINT WAS POWDERCOAT, REF. PARTS-226	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE * GASKET	CP	06.12.16
C	ADD -043; NEW INSERTS	CP	06.03.16
B	MOVE SADDLE HOLE-42.14 WAS 42.78	CP	04.06.09
A	NEW ISSUE	CP	04.03.15
DESIGN	CP	BY	DATE
DRAWN	RF		
CHECKED	AK		
MFG. APPR.	JLM		
APPROVED	DS		
DE APPR.	DS		
DATE	16.04.25		
DART AEROSPACE USA, INC			
EUGENE, OR			
DRAWING NO. D3274			
TITLE SKIDTUBE ASSEMBLY			
SHEET 1 OF 5			
REV. G			
SCALE			
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



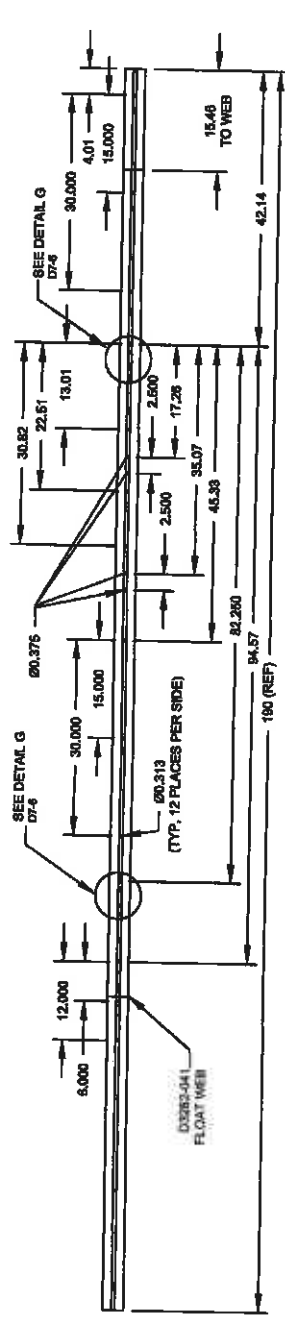
D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

DESIGN	CP	DART AEROSPACE USA, INC
DRAWN	RF	EUGENE, OR
CHECKED	AK	
MFG. APPR.	JLM	DRAWING NO. D3274
APPROVED	DS	REV. G
DATE	16.04.25	SHEET 2 OF 6
		SCALE
		NTS

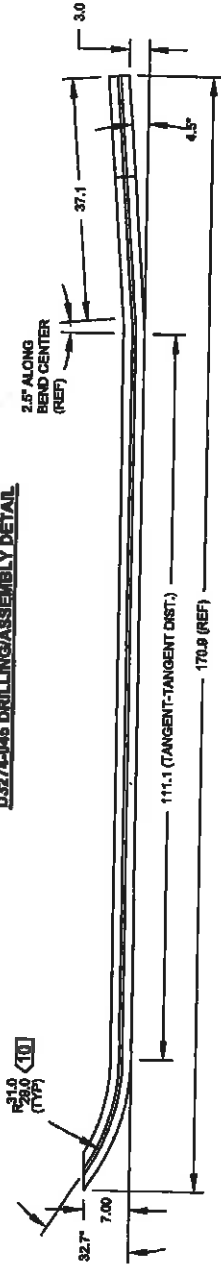
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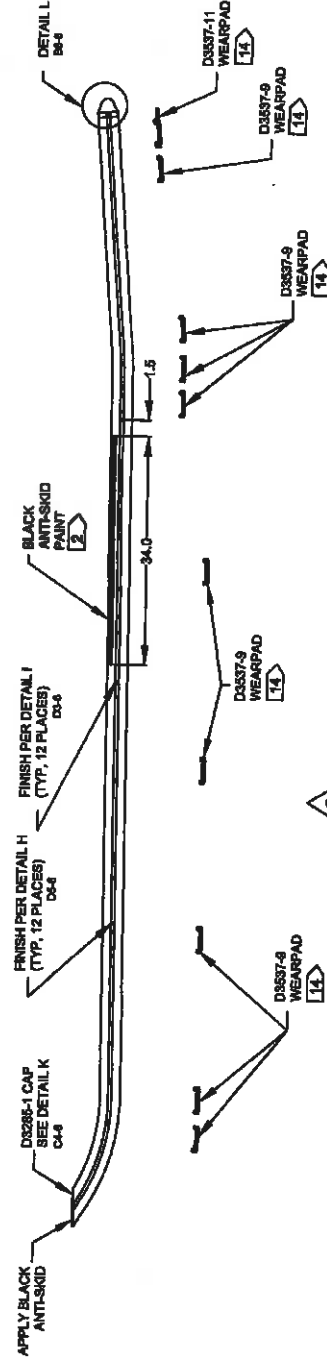
RELEASED
2016-07-26



D3274-045 DRILLING/ASSEMBLY DETAIL



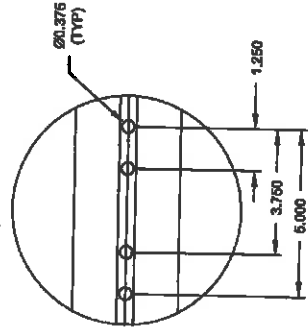
D3274-045 BEND/DRILLING DETAIL



DESIGN	CP	DART AEROSPACE USA, INC
DRAWN	RF	EUGENE, OR
CHECKED	AK	DRAWING NO.
MFG. APPR.	JLM	D3274
APPROVED	DS	REV. G
DE APPR.	DS	SHEET 4 OF 8
DATE	16.04.25	TITLE
		SKIDTUBE ASSEMBLY
		SCALE
		NTS

RELEASED
2016-07-26

DETAIL A: DRILL DETAIL
B4-2, D34, D34-3, D34-3



DETAIL B
B4-2, B4-3

FOR Ø0.375 HOLES ONLY

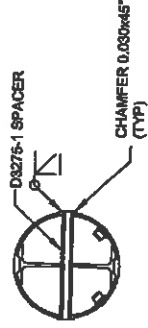


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:

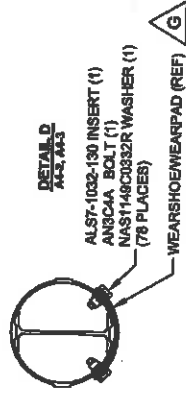
1. CHAMFER HOLE 0.030x45°
2. INSERT D2848 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CSORE TO Ø0.313x0.75 DEEP

DETAIL C
B4-2, B4-3

FOR Ø0.313 HOLES ONLY

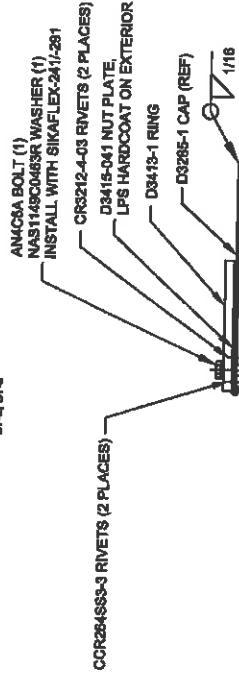


DETAIL D
A4-2, A4-3



- ALS7-1022-130 INSERT (1)
- AN8C44 BOLT (1)
- NAS1148C0332R WASHER (1)
- (78 PLACES)

DETAIL F: END FINISHING DETAIL
B7-2, B7-3



- AN8C8A BOLT (1)
- NAS1148C0468R WASHER (1)
- INSTALL WITH SIKAFLEX-241/281

- CR3212-403 RIVETS (2 PLACES)
- D3415-041 NUT PLATE
- LPS HARDCOAT ON EXTERIOR
- D3418-1 RING
- D3285-1 CAP (REF)

REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

- AN8C44 BOLT (1)
- NAS1148C0332R WASHER (1)
- D3872-1 WASHER (1)
- INSTALL WITH SIKAFLEX-241/281

SEAL WITH
SIKAFLEX-241/281
ADHESIVE

Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2848 CAP
BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

- 1. CUT TUBE LEVEL
- 2. REMOVE RIDGE ON FWD SIDE
- 3. LOCATE D3415-041 (TRIM AS NECESSARY)
- 4. WELD D3415-041 IN PLACE PER DART 081 004
- 5. GRIND FLUSH
- 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3418-041
PRIOR TO FINISH

-041-043 DETAILS

RELEASED
R 2016-07-26

DESIGN	CP	RF	AK	JLM	DJB	DATE	16.04.25	1
DRAWN								
CHECKED								
MFG. APPR.								
APPROVED								
DE APPR.								
DATE								
REV. G								
DRAWING NO.								
SHEET 5 OF 8								
TITLE								
SKIDTUBE ASSEMBLY								
SCALE								
NTS								

COMPONENT 5 SUB BY DART AEROSPACE USA, INC.
NOT TO BE USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.



Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging ☐ Engineering Water Jet Supplier Quality ☐ ☐ ☐	
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			